

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028605**Date Inspected:** 13-Oct-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Ultrasonic Testing of ESW**ESW T, Face B:**

This QA performed Ultrasonic Testing (UT) of Tower Electroslag Complete Joint Penetration (CJP) shear plate welds designated as "ESW T" on face B.

This weld was tested in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R5.

Due to safety concerns and access, testing was performed in tandem using Quality Control Technician Andrew Keech's scope. This QA observed Mr. Keech calibrate his scope and perform testing on this date.

The following indications were observed as having a transverse orientation. Due to joint configuration and weld cap shape these indications could not be evaluated for length or "X" location.

Y locations are recorded as:

Indication #1: Y= 490mm

Sizing – A=66db, B= 43db, C= 11db, D= 12db

Sound Path= 160mm, Depth= 56mm

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Indication #2: Y= 510mm

Sizing – A=71db, B= 43db, C= 5db, D= 23db

Sound Path= 84mm, Depth= 30mm

Indication #3: Y= 545mm

Sizing – A=70db, B= 43db, C= 10db, D= 17db

Sound Path= 148mm, Depth= 54mm

Indication #4: Y= 680mm

Sizing – A=72db, B= 43db, C= 8db, D= 21db

Sound Path= 133mm, Depth= 47mm

Indication #5: Y= 835mm

Sizing – A=72db, B= 43db, C= 8db, D= 21db

Sound Path= 122mm, Depth= 43mm

Indication #6: Y= 890mm

Sizing – A=62db, B= 43db, C= 5db, D= 14db

Sound Path= 93mm, Depth= 33mm

Indication #7: Y= 1090mm

Sizing – A=73db, B= 43db, C= 11db, D= 19db

Sound Path= 165mm, Depth= 59mm

Indication #8: Y= 1215mm

Sizing – A=72db, B= 43db, C= 9db, D= 20db

Sound Path= 138mm, Depth= 50mm

Indication #9: Y= 1270mm

Sizing – A=66db, B= 43db, C= 6db, D= 17db

Sound Path= 101mm, Depth= 36mm

Indication #10: Y= 1330mm

Sizing – A=72db, B= 43db, C= 8db, D= 21db

Sound Path= 133mm, Depth= 48mm

Indication #11: Y= 1535mm

Sizing – A=62db, B= 43db, C= 5db, D= 13db

Sound Path= 87mm, Depth= 31mm

Indication #12: Y= 1560mm

Sizing – A=72db, B= 43db, C= 10db, D= 19db

Sound Path= 150mm, Depth= 54mm

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversation was relevant to testing performed during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Reyes, Danny	QA Reviewer
